										<u> </u>		
Work Ord Tuesday, Octob				*125	257*	٠.	· · · · · · · · · · · · · · · · · · ·		,	,	Page 1	
Item ID: Revision ID:	D3391-023			Accept	*N900	0040	100)* 8	Setup Sta	rit *N	S1*	-
Revision 1D: Item Name:	Mid Tube As	sembly	1.10		·				Sto		S2*	
Start Date:	9/25/14	Start Qty: 1.00	* *1*		Cust Item	ID:						
Required Date:	: 10/06/14	Req'd Qty: 1.00	*1*		Customer							
Reference:		•							_			
Approvals:	Process Pl	an: MLS	Date: 14-10-0	Tooling:	D	ate:		R	Run Sta	~1 <i>/</i> 1	R1*	
	QC:		_ Date:	_ SPC (Y/N):	D	ate:			Sto	^{''} *N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Re	vision Nbr	- Alexander	~.								
D3391	I			3								
100				0.00								-
100		Skidtubes										
Skidtubes		Memo		0.00								
Skidtubes		1-Cut tube t	to finish length as per Dwg	g D3391)						
		-	t holes using DT8796 (Do on one side only as per Dy	not drill "B" holes) and dri	ll only 1 fwd							
*		- A is.		-								
λ ,		3-Open sad	dies and GHW holes to ØC	0.4375" exept for fwd saddl	e hole of detail		R.C.	4-10-0	19		* * * * * * * * * * * * * * * * * * * *	
		4-Remove	030" from Fwd indexing F	tidge as ner Dwo D3391			051	710-0	′ /			
%.	t € 's				D2204			-				
Na. partie	San Carrier	₹ 📆	• [aft end of skidtube as per D	wg D3391							
200		6-Deburr	8									
*		7- Locate D	3391-021 in D3391-023 a	t 9.00" (see view z-z)								
		remaining f dia hole, us tranfer drille	wd saddle holes using DT ing t-pins and clicos to en- ed pilot holes in D3391-02	only to .188" dia, transfer d 8149 locating from previus sure perfect allingment, ope 3/-021 using drill press. and forth fwd saddles holes	sly drill .188" in up previusly	ć	BEI	4-10-	16			

per
ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".
D3391-021 BATCH: 120031

DQA:		<u></u>	Date:		*	- MODE ODDED NON	N C	ONEO		IDDATE				DART
QA Closed:			Date:			WORK ORDER NO	V-C	ONFO	RIVIAINCE / C		Vork Order uj	odate only		AEROSPACE
Work Orde	·r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	lo					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update	:	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	CI	nief Eng	Desc	ription	Date	Verification	1 <u> </u>	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
<u> </u>					L		FA	ULT CAT	EGORY		<u> </u>			
Landin	ıg Ge	ar				General								
	Be Cr Cr Cr In	ending entre No racks rimp/Kin uffs rushing eat Trea spection arks/Ch urning Se	n Strip in atter equence	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/U ions Incomplete/ ned/off center iled	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Se Te W	ressure/Forced et-up emperature/Cure reld rong Stock Pulled
	W	ave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

W	ork	Order	ID	125257
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105057

Page 2

Tuesday, Octobe	er 07, 2014	10:39:21 AM		* 12!	つどり / ^	`					Page 2
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube As	sembly		Accept	*N900	0401	೧ ೧*	Setup	Start Stop	*N.S	31* 20*
Start Date: Required Date: Reference:	9/25/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:				"IU."	^ "
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N);		ite:			Start Stop	*NF	
Sequence ID/ Work Center II	D	paint marke ***DO NO' Open wearp (10 holes) a: Open wearp (20 holes) a: ***DO NO' Deburr and aft end. 10- Locating wearplte hole	r, Γ DRILL HOLES #3-19-2 late holes of D3391-023 a s per Dwg D3391 late holes of D3391-023 a s per Dwg D3391 Γ OPEN 2 MOST FWD V blow out all chips from in		IIG G to Ø0.250" H to Ø0.297" n D3391-023 at	Tool# PI	lan Accep ode Qty	Qty	N		Insp. Stamp
110 *110* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00				<u> </u>	<u>(-10</u> 2		0 _{AS} 9-89

DQA:			Date:										•	TQAR [*]
						WORK ORDER NON	-C(ONFO	RMANCE / UPDATE				r—	AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Ord	er:					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS		
	-	,			_	Rework]		Skid-tube Crosstube	Г]	Water Jet		Engineering
Part I	No.	•				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.		Quality
	•					Use-as-is			noforming Finishing	-	8	re/Packaging		Other
NCR I	۷o. ₋					Suspected Unapproved			Large Fab Composite	-		Supplier	-	
Root					Descr	iption of work order update		nitial	Action		Sign &		_	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design												•		
Doc/Data	Ш													
Equip/Tooling	Ш													
Handling/Pre	Ш			·										
Material	Ш													
Operator	Ш													
Offset/Setup	Ш					, /								
Process	Н													
Supplier						/								ı
Training -	$\vdash\vdash\vdash$												İ	
Transport	Н	·												
Unapproved	<u></u>			<u> </u>			EAI	UTCAI	l regory					
Landi	nø G	iear	· · · · · · · · · · · · · · · · · · ·			General		DEI CAI	IEGORI		:	····		
Landi		Bending				Bend		Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
	\vdash	Centre No	t Concer	ntric		BOM/Route		Grain	10814111		Over/Under		$\vdash \vdash$	Set-up
	\vdash	Cracks				Broken/Damage/Defect		Hardwa	re	\vdash	Part Incorrec	4	_	Temperature/Cure
	\vdash	Crimp/Kin	k/Ripple	/Wave		Burrs	Н		on Incomplete/Unqualified	-	Part Lost/Mi		-	Weld
	-	Cuffs	- • •	-		Contamination	-	-	ions Incomplete/Unclear	_	Part Moved	· .	-	Wrong Stock Pulled
		Crushing				Countersink			ned/off center	-	Positioned W	/rong		-
		Heat Trea	t			Cut Too Short	\vdash	Mislabe			Power Loss/S	-		Other
		Inspection	Strip in	Tube		Drawing		Misread	1		<u> </u>			
		Marks/Ch	atter			Drill Holes		Off-set		•				
		Turning Se	equence			Finish		Out of C	Calibration	•				
		Wave/Twi	st in Tub	e		Fit/Function		Out of S	Sequence	•				

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Work Order ID 12525	Order ID	12525	1
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125257

Page 3

Insp.

Stamp

Tuesday, October 07, 2014 10:39:21 AM D3391-023 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* Start Qty: 1.00 **Start Date:** 9/25/14 **Cust Item ID:** Required Date: 10/06/14 **Req'd Qty:** 1.00 *1* **Customer:** Reference: Run Start Process Plan: **Tooling:** Approvals: Date: Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Number **Work Center ID** Description **Run Hours** Code Qty Qty 120 Chemical Conversion Coat per QSI005 4.1 0.00 *120* 14-10-20 HandFinish 0.00 Memo

130

QC7-Inspect Chemical Conversion Coat

0.00

130

Hand Finishing

QC **Quality Control**

Memo

0.00

DQA:			Date:										·	TQAC.
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:			· · · · · · · · · · · · · · · · · · ·		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		W	ork Order up	odate only		
Work Orde	or.					DISPOSITION			AGA	INST DI	PARTMENT	/PROCESS		
Work Orac						Rework			Skid-tube Cross	tuhe	7	Water Jet		Engineering
Part N	No.					Scrap			Machining Small	ļ	Pro	d. Eng. Coor.	М	Quality
						Use-as-is			~ 	hing	┥	re/Packaging	П	Other
NCR N	No					Suspected Unapproved			Large Fab Compo]	Supplier		
Root					Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup	Ш					,							ļ	
Process														
Supplier														
Training														
Transport									·					
Unapproved														
							FAL	JLT CA1	EGORY					
Landi						General.					7	1		
	\vdash	ending				Bend	$\overline{}$		rogram	_	Outside Dim		${f -}$	Pressure/Forced
	\vdash		t Concer	ntric		BOM/Route	\dashv	Grain		<u> </u>	Over/Under			Set-up
	\vdash	racks		4		Broken/Damage/Defect	\blacksquare	Hardwa			Part Incorred			Temperature/Cure
	\vdash	•	k/Ripple,	/Wave		Burrs		-	on Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	\vdash	Weld
		uffs				Contamination			ions Incomplete/Unclear	<u> </u>	Part Moved			Wrong Stock Pulled
	-	rushing				Countersink	-	_	ned/off center	<u> </u>	Positioned W	-		
	-	eat Trea		- 1		Cut Too Short		Mislabe		<u> </u>	Power Loss/S	surge		Other
			Strip in	Tube		Drawing		Misread						
		larks/Ch				Drill Holes	-	Off-set	S 19			· · · · · · · · · · · · · · · · · · ·		
		urning Se			\vdash	Finish	-		Calibration					
	\ <u></u>	/ave/Twi	st in Tub	e		Fit/Function		Out of S	equence					

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Work Ord	er ID 12	5257	
Tuesday, Octob	er 07, 2014 10	0:39:21 AM	
Item ID:	D3391-023		
Revision ID:			
Item Name:	Mid Tube Asse	embly	
Start Date:	9/25/14	Start Qty:	1.00
Required Date	: 10/06/14	Req'd Qty:	1.00

QC:

Process Plan:

Operation

Description

Skidtubes

Page 4

^ I > !	シンン・							1 age	
Accept	*N900	040	100)* s	etup	Start	*N	S1*	_
						Stop	*N	S2*	
	Cust Item II Customer:	D:							
Tooling:	Da	nte:	_	R	un	Start	*N	R1*	
SPC (Y/N):		ite:				Stop	*N	R2*	
Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	ject V	Reject Number	Insp. Stamp	
0.00					-	•			-
& QSI 015.		A) /	4-10	ク -	22	>		•
AFT END OF TUBE								DA 18 9-8:	}
0.00									"

150

Reference:

Approvals:

Sequence ID/

140

Skidtubes

Skidtubes

140

Work Center ID

QC5- Inspect part completeness to step on W/O

150

Memo

Memo

Quality Control

0 1410-21

0.00

Accept

3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015.

1

1

Date:

Date:_____

Adhere for 12 hours)

A/R Sikaflex exp: 14-11-20

batch#: 129457

NOTE:ENSURE WEB IS INSERTED IN AFT END OF

1-Open float bag holes as per dwg

2-C'sink float bag holes as per dwg

DQA:			Date:									•	T A A C
						WORK ORDER NON	-C(ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:		` _					V	Vork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	D
	-					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing	-	re/Packaging	Other
NCR 1	No		-10	· · · ·		Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design													
Doc/Data	Ц												
Equip/Tooling	Ш												
Handling/Pre						· ·		3 ~					
Material	Ш										İ		
Operator	Ш]						
Offset/Setup	Ш								~				1
Process	\Box												
Supplier							ļ				ļ		
Training													
Transport	Ш												
Unapproved													
							FA	JLT CAT	EGORY				
Landi						General		1 .			- -	_	7
	-	Bending				Bend			rogram		Outside Dim	 	Pressure/Forced
	-	Centre No	t Concer	ntric		BOM/Route		Grain	•	_	Over/Under		Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa		<u>_</u>	Part Incorred		Temperature/Cure
	-	Crimp/Kin	ık/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/Ui	nqualified	Part Lost/Mi	ssing	Weld
	_	Cuffs			-	Contamination			ions Incomplete/l	Unclear	Part Moved		Wrong Stock Pulled
	\vdash	Crushing				Countersink	$\overline{}$	_	ned/off center		Positioned V		_
	-	Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge	Other
		Inspection	•	Tube		Drawing	Ш	Misreac	I				
	_	Marks/Ch				Drill Holes	Ш	Off-set					
!	_	Turning Se				Finish	\vdash		Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	equence				

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Work Order ID 125257

125257

Page 5

Tuesday, October 07, 2014 10:39:21 AM D3391-023 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop Item Name: Mid Tube Assembly *1* Start Qty: 1.00 **Start Date:** 9/25/14 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 10/06/14 *1* **Customer:** Reference: Start Run Process Plan: Date: **Tooling:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ **Operation** Accept Work Center ID Description Oty Oty Number Stamp Code **Run Hours** 160 0.00 Skidtubes *160* Skidtubes 0.00 Memo 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 A/R m/29285 Skidtubes 2-grind weld flush 170 QC10- Inspect visual per QSI004- ground welds 0.00 M 14102) *170* DAS 0.00 Memo 9-89 Quality Control QC5- Inspect part completeness to step on W/O 180 0.00 (C. O.N. @ *120* DAS 9 QC 0.00 Memo 9-89 **Quality Control**

DQA:			. Date:			_							~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	
						WORK ORDER NON	-C	ONFO	RMANCE / UP				A E R	ROSPACE
QA Closed:			Date:			<u> </u>		r			Vork Order up	odate only		
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Work Orde						Rework	1		Skid-tube	Crosstube	٦	Water Jet	Enginee	ring
Part N	ln					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	_	ality
	_					Use-as-is	1		noforming	Finishing	⊣	re/Packaging		ther
NCR N	lo.					Suspected Unapproved			Large Fab	Composite	1	Supplier		
	_						_1		٠ ـــا		_	, , ,		
Root					Desc	ription of work order update		Initial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verificatio	n QC Ins	spector
Design														
Doc/Data	_													
Equip/Tooling														
Handling/Pre	_													
Material														
Operator														
Offset/Setup														
Process														
Supplier				i										
Training	_													
Transport														
Unapproved				i							·	·		
							FA	ULT CAT	regory		1114 #1080 # 81 /			
Landin					_	General	_	1 .				•	 1	
		ending			<u> </u>	Bend		1	rogram		Outside Dim		Pressure/Fo	orced
_	_		ot Concer	ntric		BOM/Route		Grain			Over/Under		Set-up	
	_	racks			-	Broken/Damage/Defect		Hardwa			Part Incorred		Temperatu	ire/Cure
			ık/Ripple	/Wave		Burrs		1	on Incomplete/Unc	 	Part Lost/Mi	ssing	Weld	
	-	uffs			<u> </u>	Contamination		4	ions Incomplete/Ur	nclear	Part Moved		Wrong Stoo	ck Pulled
		rushing			<u> </u>	Countersink	<u> </u>	₹ "	ned/off center	<u> </u>	Positioned V	· ·	_	
		leat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe		<u> </u>	Power Loss/	Surge	Other	
	-	•	n Strip in	Tube		Drawing	<u></u>	Misread	d					
	_	/larks/Ch			<u> </u>	Drill Holes	<u></u>	Off-set						
		•	equence		<u> </u>	Finish	<u></u>	i	Calibration					
i I	I۷	Vave/Twi	ist in Tuh	e		Fit/Function	1	I Out of 9	Sequence					

Work Ord Tuesday, Octob				*12	25257*		
Item ID: Revision ID:	D3391-023			Accept	*N900040100*	Setup	Start
Item Name:	Mid Tube As	ssembly					Stop
Start Date:	9/25/14	Start Qty: 1.00	*1*		Cust Item ID:		
Required Date	: 10/06/14	Req'd Qty: 1.00	*1*		Customer:		
Reference:			•				
Approvals:	Process Pl	an:	Date:	Tooling:	Date:	Run	Start

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	Pressure Wash per QSI005 4.3	0.00					1	1.0	
185 HandFinish	Мето	0.00				12	4	<u>Ill</u> 1,	alcol 27
Hand Finishing	✓ AND REALODINE AS PER PAR09-043						•		

Date:

Hand Finishing AND REALODINE AS PER PAR09-043

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

100
Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

OVEN TEMPERATURE

FINISH TIME:

OVEN TEMPERATURE

FINISH TIME:

OVEN TEMPERATURE

QC: Date: SPC (Y/N):

OVEN TEMPERATURE
FINISH TIME:

200
QC3- Inspect Part Finish
0.00

200
QC Memo 0.00
Quality Control

1 6 14-10-30 353

Stop

Page 6

NS2

NR2

DQA:			Date:			WORK ORDER NON	I- <i>C</i> (ANEO!	DMANCE / I	IDDATE				ART
QA Closed:			Date:			WORK ORDER NON	1-C	JNFO	RIVIAINCE		Vork Order u	odate only	A	EROSPACE
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	٠ . No					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	a	eering Quality Other
Root					Desc	ription of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cr	ief Eng	Desc	ription	Date	Verification	QC I	nspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CAT	TEGORY					
Landir		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection	nk/Ripple	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspecti Instruct	ion Incomplete/U tions Incomplete/ gned/off center eled	Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure, Set-up Tempera Weld Wrong St	nture/Cure
		Marks/Ch Turning So Wave/Tw	atter equence			Drill Holes Finish Fit/Function		Off-set Out of (Calibration Sequence					

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			204									
Work Ord Tuesday, Octobe				*125	5257*							Page 7
Item ID: Revision ID:	D3391-023			Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Mid Tube As	sembly								Stop	*NI	S2*
Start Date: Required Date: Reference:	9/25/14 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					10	()/
Approvals:	Process Pl	an•	Date:	Tooling:	D:	ate:	_		Run	Start	*N	R1*
Approvais.	QC:	an.	Date:	SPC (Y/N):		ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
220 HandFinish Hand Finishing	·	HandFinishing Memo 1-Install Inse	erts as per Dwg	0.00				16	- 4	<u>/</u>		ululos
240 *** 0 4.0*		QC5- Inspect part compl	eteness to step on W/O	0.00		-		1				DAS .38 9-89 4-
* 940* QC Quality Control		Memo		0.00								203 14-11

250

Identify as per dwg & Stock Location: wlo

0.00 P412-742-043/B124112 14 & Al 14/11/03

250
Packaging

Memo

Packaging

DQA:		_ Date:										TQAR.
					WORK ORDER NON-	-C(ONFO	RMANCE / UPD				AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Orde	ar:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE	····				Rework	ı		Skid-tube 0	Crosstube	1	Water Jet	Engineering
Part N	lo				Scrap			—	Small Fab	Pro	d. Eng. Coor.	Quality
raici					Use-as-is			noforming	Finishing	4	e/Packaging	Other
NCR N	lo				Suspected Unapproved		,,,,,,,,	~ —	Composite	,	Supplier	
			T	D	· · · · · · · · · · · · · · · · · · ·		:4:-1	A		C: 0		
Root	Data	Ston	Oty	Desci	ription of work order update or non-conformance		nitial iief Eng	Action		Sign & Date	Verification	QC Inspector
Cause	Date	Step	Qty		or non-comormance	Ci	ner eng	Descript	.1011	Date	vernication	QC Inspector
Design Doc/Data	-											
Equip/Tooling	\dashv											
Handling/Pre												
Material	\dashv											
Operator												
Offset/Setup	=											
Process	_											
Supplier												
Training												
Transport												
Unapproved												
						FA	ULT CAT	TEGORY				
Landir	ng Gear				General					_		_
	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	Centre N	lot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorrec	t	Temperature/Cure
١	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqua	alified	Part Lost/Mis	ssing	Weld
	Cuffs				Contamination		ł	tions Incomplete/Uncl	lear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink		1	gned/off center		Positioned W		-
	Heat Tre				Cut Too Short	_	Mislabe			Power Loss/S	Surge	Other
	→ '	on Strip in	Tube		Drawing		Misread				<u></u>	····
	Marks/C				Drill Holes		Off-set					
		Sequence			Finish		4	Calibration				
	Wave/T	wist in Tub	e		Fit/Function		Out of 9	Sequence				

Work Orde				*125257*									
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube A			Accept	*N900	0401	೧೧ *	Set	tup Start Stop	1/1/2			
Start Date: Required Date: Reference:	9/25/14 10/06/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		Ru	n Start Stop	^IVI F			
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID		an Acc	_	•		Insp. Stamp		

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

Quality Control

260

April-04

DQA:			Date:		···	WORK ORDER NON	c	ANEO	DMANCE / I	LIDDATE				3	DART
QA Closed:			Date:			WORK ORDER NON	-((JNPOI	AIVIAINCE / (Work O	rder u	odate only		AEROSPACE
Work Orde)r.	· · · · · · · · · · · · · · · · · · ·		*****		DISPOSITION				AGAINST	DEPART	MENT	/PROCESS		
Work Orde						Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	10.					Scrap	1	1	Machining	Small Fab		Pro	d. Eng. Coor.	├	Quality
	_					Use-as-is	1	1	noforming	Finishing	R		re/Packaging	-	Other
NCR N	10					Suspected Unapproved			Large Fab	Composite			Supplier	-	
Root					Desci	ription of work order update		Initial	Α	ction	Sig	gn &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	2	ate	Verificatio	n	QC Inspector
Design	_														
Doc/Data	_														
Equip/Tooling	_														
Handling/Pre															
Material	_														
Operator							ĺ								
Offset/Setup	_														
Process	_														
Supplier	\dashv														
Training	-														
Transport	-														
Unapproved							<u> </u>	UTCAT	ECODY.		L				
							FA	ULT CAT	EGURY						
Landin [General Bend	_	l==:=/p		ſ		: d - D:		$\overline{}$	Pressure/Forced
-	_	ending	t Concer	trio		BOM/Route	-	Grain	rogram	ŀ			ensions tolerance	_	Set-up
-	_	racks	it Concer	ICFIC	-	Broken/Damage/Defect		Hardwa		ļ		Incorre		\vdash	Temperature/Cure
-			k/Ripple	Maria		Burrs	-	ł	re on Incomplete/l	Ungualified	→	Lost/Mi		-	Weld
	_	uffs	k) kippie,	, wave		Contamination		ł	ions Incomplete,		_	Lost/ivii Moved	22111B	\vdash	i
}		rushing			-	Countersink	<u> </u>	ł	ned/off center	•	_	ioned V	Vrong	Щ	Wrong Stock Pulled
}	_	eat Trea	t		-	Cut Too Short	$\overline{}$	Mislabe		ŀ		er Loss/	-		Other
}			Strip in	Tube		Drawing	\vdash	Misread		l		LI LU33/	Juige	L	Todie:
}		1arks/Ch	•	· ubc		Drill Holes	-	Off-set	•						
ļ	_	urning Se				Finish	\vdash	Í	Calibration						
.	_		ist in Tub	е		Fit/Function		i	Sequence						

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Picklist Print

Tuesday, October 07, 2014 10:39:21 AM

Work Order ID: 125257

125257

Parent Item:

D3391-023

D3391-023

Parent Item Name:

Mid Tube Assembly

Start Date: 9/25/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.10.20New Issue

KJ/EC

IPP B06.02.10ECN773 dwg rev.D

EC

IPP C 07.03.20 rev F dwg IPP D 07.03.28

EC

re-format

EC EC

IPP E 07.10.31 ecn 1053P

IPP Rev:F ECN 1056 07-11-13 DD IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

verified by: EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

No

Manufactured

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP

Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	57.0000	1	1			
D2500-1-	-100								**		BEI	40	09

Location	Loc	c Oty	Loc Code		
HALL		57			
82373		8			/_
86065		49			
	140	Each	6.0000	1	1

D3389-1

Web

D3389-1

Location	Loc Oty	Loc Code
LG	6	
(-1:15652)	6	



DQA:		Date:											TRAC
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	r:	-			DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N	0.			:	Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update	1	nitial	Act	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design													
Doc/Data													
quip/Tooling													
landling/Pre		1											
Material [
Operator													
Offset/Setup													
rocess		Ì											
upplier													
raining													
ransport													
Jnapproved													
						FAL	JLT CAT	EGORY					
Landin	g Gear				General								
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	t	Temperature/Cure
	Crimp/Kir		Burrs		Inspecti	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing	Weld		
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear		Part Moved		Wrong Stock Pulled
Crushing Countersink					Countersink		Misalig	ned/off center			Positioned W	/rong	_
	Heat Trea	t			Cut Too Short		Mislabe	led			Power Loss/S	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misread		,			·	
	Marks/Ch	atter			Drill Holes		Off-set						
	Turning S	equence			Finish		Out of C	alibration					
Γ	Wave/Tw	ist in Tub)e		Fit/Function	П	Out of S	eallence					

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Tuesday, October 07, 2014 10:39:21 AM

Work Order ID: 125257

125257

Parent Item:

D3391-023

D3391-023

Parent Item Name:

Mid Tube Assembly

Start Date: 9/25/14

Required Date: 10/06/14

**

Start Qty: 1.00

Required Qty: 1.00

D3681-1

Manufactured

Each

80 40 40

> 3 3

83.0000

D3681-1

Spacer

Location Loc Qty Loc Code

160

LG LG001

ALS4-1032-130

AELS4-1032-130 Purchased

No

230

3,693.000 Each

20

20

**

BE14-10-21

AI S4-1032-130

Rivnut

Location	Loc Qty	Loc Code
ST267	3693	
M126109	57	
M128211	48	
M128649	3588	

D3591-1/B115533 (x2) Al 1411/03 Bushina Spacen

DQA:			Date:		WORK ORDER NON-CONFORMANCE / UPDATE								DART	
QA Closed:			Date:			WORK ORDER NON	-C(JINFUI	RIVIAINCE / C		/ork Order up	odate only	AEROSPACE	
······································			· · ·			DISPOSITION					EPARTMENT,			
Work Orde	er: _						,				, ¬	·		
						Rework		l	Skid-tube	Crosstube		Water Jet	Engineering	
Part N	۱o					Scrap		1	Machining	Small Fab		d. Eng. Coor.	Quality	
						Use-as-is		1	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	۷٥					Suspected Unapproved]		Large Fab	Composite		Supplier		
Root					Desci	ription of work order update		Initial	А	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector	
Design														
Doc/Data	Ш											}		
Equip/Tooling	Ш											}		
Handling/Pre														
Material	Ц											}		
Operator -	Ш											}		
Offset/Setup												}		
Process												}		
Supplier														
Training	Ш													
Transport	Ш											}		
Unapproved							<u> </u>							
							FAI	ULT CAT	EGORY					
Landi	ng G	ear				General		1	`		7	- -	_	
		Bending				Bend		Folio/P	rogram		Outside Dim) —	Pressure/Forced	
	(Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	-	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	re	_	Part Incorred	:t	Temperature/Cure	
		Crimp/Kin	ink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part L					Part Lost/Mi	ssing	Weld				
		Cuffs	Contamination Instructions Incomplete/Unclear Part Moved					L	Wrong Stock Pulled					
		Crushing				Countersink		Misalig	ned/off center	r	Positioned W	/rong _		
		Heat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misread	1				···	
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning Se	equence			Finish		Out of C	Calibration					
						Fit/Function		Out of Sequence						

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